

**USDA, AMS,  
Livestock and Seed Program**

**APPROVED**

**ITEM DESCRIPTION AND  
CHECKLIST OF REQUIREMENTS (IDCR)  
FOR  
CANNED LUNCHEON MEAT**

Contracting Officer Technical Representative (COTR):  
Standardization Branch  
Room 2607, Phone: (202) 720-4486

**Effective March 2006**

**I. ITEM DESCRIPTION**

Items –	Canned Luncheon Meat – This canned item consists of (1) beef, (2) pork, or (3) a combination of beef and pork, that is cured and fully cooked as specified with the AMS invitation. This item is ready to serve and can be used as a sandwich component or within a variety of food dishes.
Formula –	This item consists of not less than 97 percent meat computed on the weight of the fresh meat. Beef and pork combination shall consist of not less than 30 percent beef or 30 percent pork.
Fat/Sodium –	Fat must not exceed 8 g (grams) per 56 g serving. A labeling claim of “Less sodium” is required on both the immediate and shipping containers.
Cans/Cases	Individual cans shall have a net weight of 12, 24, or 30 ounces (The AMS invitation shall specify can size). Twenty-four (24) cans shall be unitized to a net weight of 18, 36, or 45 pounds respectively.

**II. CHECKLIST OF REQUIREMENTS**

Canned meat items must be produced in accordance with Food Safety Inspection Service (FSIS) regulations and this checklist of requirements below.

**A. MATERIALS**

The contractor’s technical proposal must describe a process plan with a documented quality control program that includes procedures, records, forms, etc. that demonstrate conformance with the following Checklist of Requirements.

**1. MEAT COMPONENT**

Beef or pork shall be the only meat component allowed.

- a) Domestic Origin – All beef and pork shall originate from U.S. produced livestock as defined in section I.F. of this announcement.

- b) Harvest (Slaughter) Requirements – Boneless meat shall be derived from livestock harvested at facilities that comply with the following harvest requirements.
  - (1) Humane Handling – All livestock shall be humanely handled in accordance with all applicable FSIS regulations, directives, and notices.
  - (2) Non-Ambulatory Disabled Livestock – Meat from carcasses of non-ambulatory disabled livestock shall not be included in USDA purchased canned meat products.
  - (3) Spinal Cord Removal – All spinal cord tissue shall be removed. For cattle, all spinal cord tissue must be removed during the harvesting process.
- c) Meat Composition – This item consists of not less than 97 percent of meat computed on the weight of the fresh meat. Beef and pork combination shall consist of not less than 30 percent beef or 30 percent pork.
- d) Boneless Meat Requirements
  - (1) Traceability – Boneless meat shall be traceable to sources that comply with the above domestic origin and harvest requirements.
  - (2) Handling - All boneless meat must be maintained in excellent condition. The contractor's technical proposal shall include detailed production scheduling that addresses time and temperature controls necessary to maintain excellent condition of the boneless meat.
  - (3) Objectionable Materials – Boneless meat must comply with the following:
    - (a) Beef – The following objectionable materials shall be excluded:
      - (i) Major lymph glands (*prefemoral*, *popliteal*, and *prescapular*), *thymus* gland, and the *sciatic (ischiatric)* nerve (lies medial to the outside round).
      - (ii) All bone, cartilage, and the following heavy connective tissues.
        - (a) White fibrous – Shoulder tendon, elbow tendon, silver skin (ventral side of the outside round), *sacrosciatic* ligament, opaque *periosteum*, *serous* membrane (*peritoneum*), tendinous ends of shanks, *gracilis* membrane, *patellar* ligament (associated with the *stifle* joint), and *achilles* tendon.
        - (b) Yellow elastin – Back strap and *abdominal tunic*. All boneless beef suppliers must assure the removal of all bone, cartilage, major lymph glands (*prefemoral*, *popliteal*, and *prescapular*), *thymus* gland, *sciatic (Ischiatic)* nerve, white fibrous connective tissue (shoulder tendon, elbow tendon, silver skin, *sacrosciatic* ligament, opaque *periosteum*, *serous* membrane or, tendinous ends of shanks, *gracillus* membrane, *patellar* ligament, and *achilles* tendon), and yellow elastin connective tissue (back strap and *abdominal tunic*)..
    - (b) Pork – All glandular material, bone, cartilage, and heavy connective tissue shall be excluded.
  - (4) Meat Recovery Systems – Boneless meat produced from the methods listed below shall not be allowed.

- (a) Mechanical Separation - Boneless meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems or powered knives, shall not be allowed.
- (b) Finely Textured Beef – Low temperature rendered beef that is processed from fat boneless meat trimmings and is finely textured is not allowed.
- (5) Pathogen Testing – Production lots of boneless beef or pork and/or ground beef or pork associated with a positive result for any pathogen shall not be allowed.

## **2. NON-MEAT COMPONENT**

The contractors shall provide a formula declaring the amount of all added ingredients.

- a) Domestic Origin of Non-Meat Component – Significant ingredients (more than 1 percent) shall be derived from U.S. produced products.
- b) Seasoning and Ingredient – Seasonings and other ingredients shall be used to produce products that are similar to commercial luncheon meat.
- c) Monosodium Glutamate (MSG) is not allowed.
- d) Non-Meat Composition – Non-meat components shall not exceed 3 percent of the total ingredients.

## **3. METAL DETECTION**

All products shall be free of metal contaminants. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The contractor's technical proposal must identify and describe the equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures.

## **B. FINISHED PRODUCT LIMITATIONS**

The declared serving size (“referenced amounts customarily consumed” (racc)) fat and sodium content shall be stated on the nutrition facts panel on each can label according to FSIS required regulations. The racc shall be 56 grams.

### **1. FAT CONTENT**

The fat content must not exceed 8 g per 56 g serving.

### **2. SODIUM CONTENT**

Luncheon meat will be produced to comply with the required labeling claim of “Less sodium” on immediate (cans) and shipping containers.

### **3. TEXTURE**

The product shall have a slight to moderate coarseness in texture and hold together as an intact unit when removed from the can.

### **4. COLOR UNIFORMITY**

The product shall be reasonably uniform in color with a slight variation between internal and external surfaces. The following color ranges are acceptable:

- a) Beef – Dark pink to reddish brown.
- b) Pork – Pink to dark pink.
- c) Beef and Pork – Dark pink to light reddish brown.

**C. PREPARATION FOR DELIVERY****1. PACKAGING**

The luncheon meat shall be filled into round or rectangular cans.

**2. PACKING**

- a) Can net weight – Individual cans shall have a net weight of 12 or 30 ounces.
- b) Case Weight – Twenty-four (24) cans shall be unitized to a net weight of:
  - 18 pounds for the 12 ounce cans.
  - 36 pounds for 24 ounce cans.
  - 45 pounds for 30 ounce cans.
- c) Case unitization – All cans shall be unitized by packing into new fiberboard shipping containers, placing on fiberboard trays with plastic shrink wrap or plastic shrink wrap only.

**3. LABELING**

Both immediate and shipping containers shall be labeled to include all information required by FSIS regulations and the following:

- a) Immediate Containers – Immediate containers shall contain the following information:
  - (1) A traceability code that identifies the establishment number, production date and production lot.
  - (2) A claim of “Less sodium”.
- b) Shipping Containers - Shipping container labels shall contain the following information:
  - (1) USDA shield at least 2 inches high and appearing on the top of the container or on the principle display panel.
  - (2) Applicable contract number.
  - (3) A traceability code that identifies the establishment number, production date and production lot.
  - (4) Nutrition facts panel based on actual nutritional analysis of the product
  - (5) A labeling claim of “Less sodium”.
  - (6) Product Code:
    - (See invitation for product code for the 12 ounce can)
    - A725 – 24 ounce can
    - A617 – 30 ounce can

**4. PALLETIZED UNIT LOADS**

All shipping containers shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic.

**D. DELIVERY UNIT****1. 12 Ounce Cans**

Each delivery unit shall consist of 2,000 shipping containers with a net weight of 36,000 pounds.

**2. 24 Ounce Cans**

Each delivery unit shall consist of 1000 cases with a net weight of 36,000 pounds.

**3. 30 Ounce Cans**

Each delivery unit shall consist of 800 cases with a net weight of 36,000 pounds.

**E. DELIVERED PRODUCT****1. SIZE AND STYLE OF CONTAINER**

Only one size and style of immediate (cans) and shipping containers may be offered in an individual shipping unit.

**2. SEALING**

All products must be delivered to AMS destinations under seal according to section I.C. of this announcement.

**F. WARRANTY AND COMPLAINT RESOLUTION****1. WARRANTY**

The contractor shall guarantee that the product complies with all contractual requirements.

**2. COMPLAINT RESOLUTION**

The contractor's technical proposal must provide the steps taken to resolve complaints received on the product i.e, point of contact, cause and effect analysis, product replacement, monetary compensation and corrective and preventative actions taken.

**G. NON-CONFORMING PRODUCT**

The contractor must include a plan to assure that non-conforming product is not delivered under USDA contracts. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product.